

Work Order ID 63524

Wednesday, November 03, 2010 2:50:26 PM

Page 1

Item ID: D206-667-103

Accept

Revision ID:

Item Name: Crosstube Fwd

Start Date: 11/3/2010 Start Qty: 1.00

Required Date: 11/18/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D206-667-143

Rev C

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels as per PPP D206-667-103 CHG004

S. Jochiz

H. Jochiz 11/01/17

110

0.00



Packaging

Packaging

Pick Kit

Packaging

Memo

0.00

DP

11-1-4

120

0.00



CNC Bend 2

CNC Alpha 160 Bender

BENDING MACHINE - CROSSTUBES

Memo

0.00

Bend tube as per Dwg D206-667-143 using CNC bender program

DP

11-1-4

D206 667 103 B63524

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC15- Crosstube Dimensional Check

0.00



0.00

Suloboy

20

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Crosstubes

0.00

Memo

Crosstubes

1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill pilot holes as per Dwg D206-667-143. Drill only the top (2) holes.

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143 Inside of Cuff (Do not engrave on outside of tube)

10-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

SAD
11-01-05

DD 11-1-6

W/O:		WORK ORDER CHANGES					
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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

SAD
10-01-06

①

Hand Finishing Crosstubes

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

S 11/01/06

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

S 11/01/06

④

Quality Control

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Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Outsource2

Outsource process - NDT per QSI038 4.1

0.00

P10:13250

0.00

Memo

CY 11/01/10 ①

Outsource process - NDT

CROSSTUBES

190



Packaging

Packaging

0.00

Memo

0.00

Packaging

Ensure copy of NDT results attached to work order.

CY 11/01/10 ①

200



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

CY 11-01-11

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Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210



SprayPaint

Spray Painting

SprayPaint

Memo

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: 11:00

Finish Time: 12:00

PAINT:

Start Time: 3:00

Finish Time: 4:00

ET 11 01 11

220



QC

Quality Control

QC14- Inspect Spray Paint

Memo

Wrap in plastic bag to protect from scratches

ml 11 01 12 (P)

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

0.00



Crosstubes

Crosstubes

Memo

0.00

(ASSEMBLE AS PER DWG D206-667-143)

1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI 015. Let cure for 12h after installation and prior to packaging. Note: (2) Aft holes should be facing up.

A/R Magnobond 6398 : 115580 exp 07/2011

11/01/17

2-Install supports and clamps as per Dwg D206-667-143. Torque clamps to 80-100 in lb.

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

Accept Qty: 11 Reject Qty: 01 Reject Number: 13 Insp. Stamp: (1)

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sub 1/17

QC: 40

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/17/10

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Sulairiz

(X)

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-667-103

Location: 53

PPP Rev: 12

11/18/10 SP 12

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/18 JH
mf
11-01-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

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Parent Item Name: Crosstube Fwd



Start Date: 11/3/2010

Required Date: 11/18/2010

Start Qty: 1.00


Required Qty: 1.00

Comments: IPP Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM
 IPP Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:
 IPP Rev: H 08.11.17 QC5 was QC6 at step 12 KJ verified by: EC
 IPP Rev:I 08-12-15 add magnobond DD verified by:EC
 IPP Rev J 09.01.06 ECN 08-562 EC verified by: DD
 IPP Rev:K 09-01-19 as per DSI9439 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-667-103TRN  Crosstube Turning DetailL		Manufactured	No	B63522		110	Each	0.0000	1	1	DP	11-1-24	
D2873-043  Nut Plate Assembly		Manufactured	No			230	Each	12.0000	2	2	M	11-01-17	

B# 63497

Location	Loc Qty	Loc Code
LG	10	
62380	10	
ST	2	
60981	2	

D2873-045  Nut Plate Assembly		Manufactured	No			230	Each	10.0000	2	2	M	11-01-17	
--	--	--------------	----	--	--	-----	------	---------	---	---	---	----------	--

B# 63498

Location	Loc Qty	Loc Code
LG	10	
60982	4	
62378	6	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Crosstube Fwd

Start Date: 11/3/2010

Required Date: 11/18/2010

Start Qty: 1.00

Required Qty: 1.00

D2891-1 Manufactured No

230 Each

51.0000

2

2



2.25 Support



11-01-13

Location

Loc Qty

Loc Code

LG

51

46159

1

50952

18

53773

20

~~62505~~

12

D3595-063-395 Manufactured No

230 Each

79.0000

4

4



RUBBER CUSHION



11-01-13

Location

Loc Qty

Loc Code

FP

10

44667

10

ST

69

63368

69

RUBBER CUSHION .63" x 3.95" (4)

MS20601-AD4W8

Purchased No

230 Each

162.0000

14

14



RIVET



11-01-17

Location

Loc Qty

Loc Code

LG

58

115855

58

ST322

104

112203

104

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Shop Packet Print

Page 2

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Start Date: 11/3/2010

Required Date: 11/18/2010

Start Qty: 1.00

Required Qty: 1.00

MS21920-20

Purchased

No

230

Each

57.0000

4

4



Clamp (per MIL-DTL-8783C)



11-01-13

Location

Loc Qty

Loc Code

LG

57

112624

2

114687

1

115057

4

115736

50

AN5-30A

Purchased

No

250

Each

100.0000

4



BOLT



11/1/12 SP

Location

Loc Qty

Loc Code

ST339

100

114941

50

116003

50

AN5-32A

Purchased

No

250

Each

252.0000

4



Bolt



11/1/12 SP

Location

Loc Qty

Loc Code

ST340

252

114405

42

115016

50

115108

50

115589

60

115698

50

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Dart Aerospace Ltd

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Required Date: 11/18/2010

Start Qty: 1.00

Required Qty: 1.00

AN5-7A Purchased No

250 Each

143.0000

10

10



Bolt

Location

Loc Qty

Loc Code

ST337

143

113149

100

115936

43

AN960JD516 NAS1149D0563J Purchased No

250 Each

34.0000

18

18



Washer

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

AN970-4 Purchased No

250 Each

101.0000

12

12



Washer

Location

Loc Qty

Loc Code

ST344

100

115936

100

ST349

1

115621

1

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Page 4

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Start Date: 11/3/2010

Required Date: 11/18/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

250

Each

731.0000

4 14



Nut



M116104

11/1/10

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

705

115156

205

115594

500

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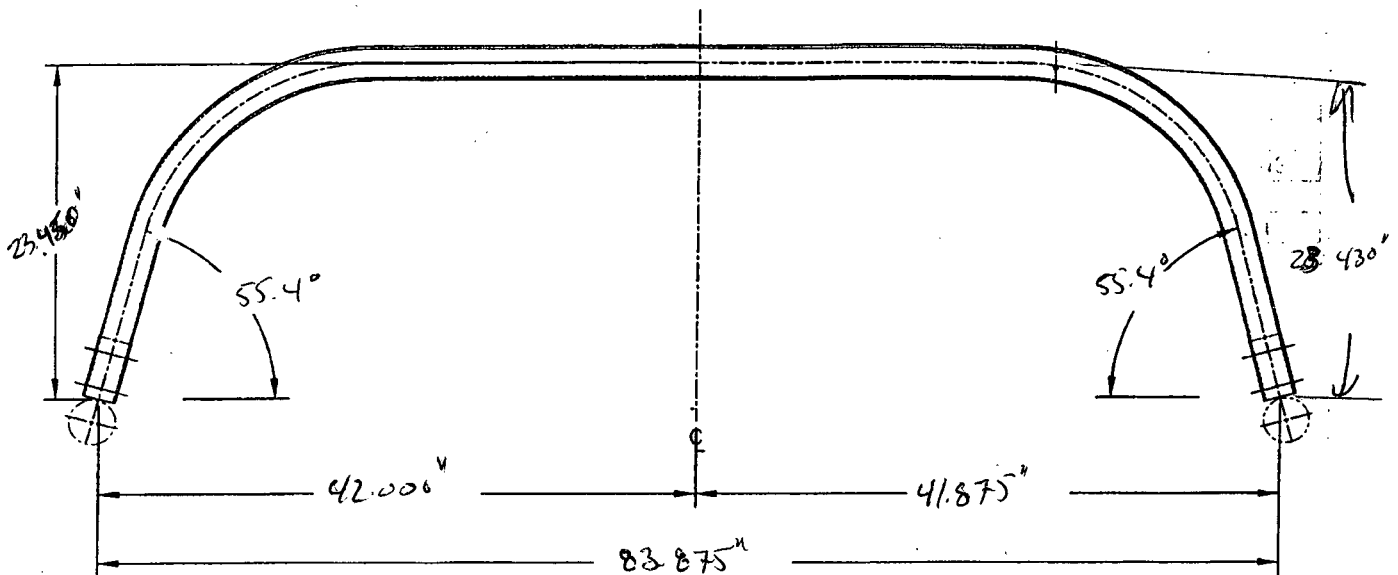
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DART AEROSPACE LTD		Work Order:	43524
Description: Crosstube High Fwd (206L)		Part Number:	D206-667-103
Inspection Dwg: D206-667-143 Rev: C		Page 1 of 1	

Required Dimension	Min	Max
Height	23.39	23.65
1/2 Span	41.79	42.05
Angle	54	56
Total Span	83.58	84.10



Comments

QC15 Inspection	S
Date	10/10/04

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	09.06.26	Dimensions updated per Dwg Rev C	KJ	
C	09.10.22	Minimum height dimension revised	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item	Qty -143	Part Number	Description
1	X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63524
pl 10-11-03

RELEASED
08/11/06

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>Q</i>	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>Q</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>Q</i>	D206-667-143	SHEET 1 OF 4
APPROVED	<i>Q</i>	TITLE	SCALE
DE APPR.	<i>Q</i>	CROSSTUBE ASSY (206L HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

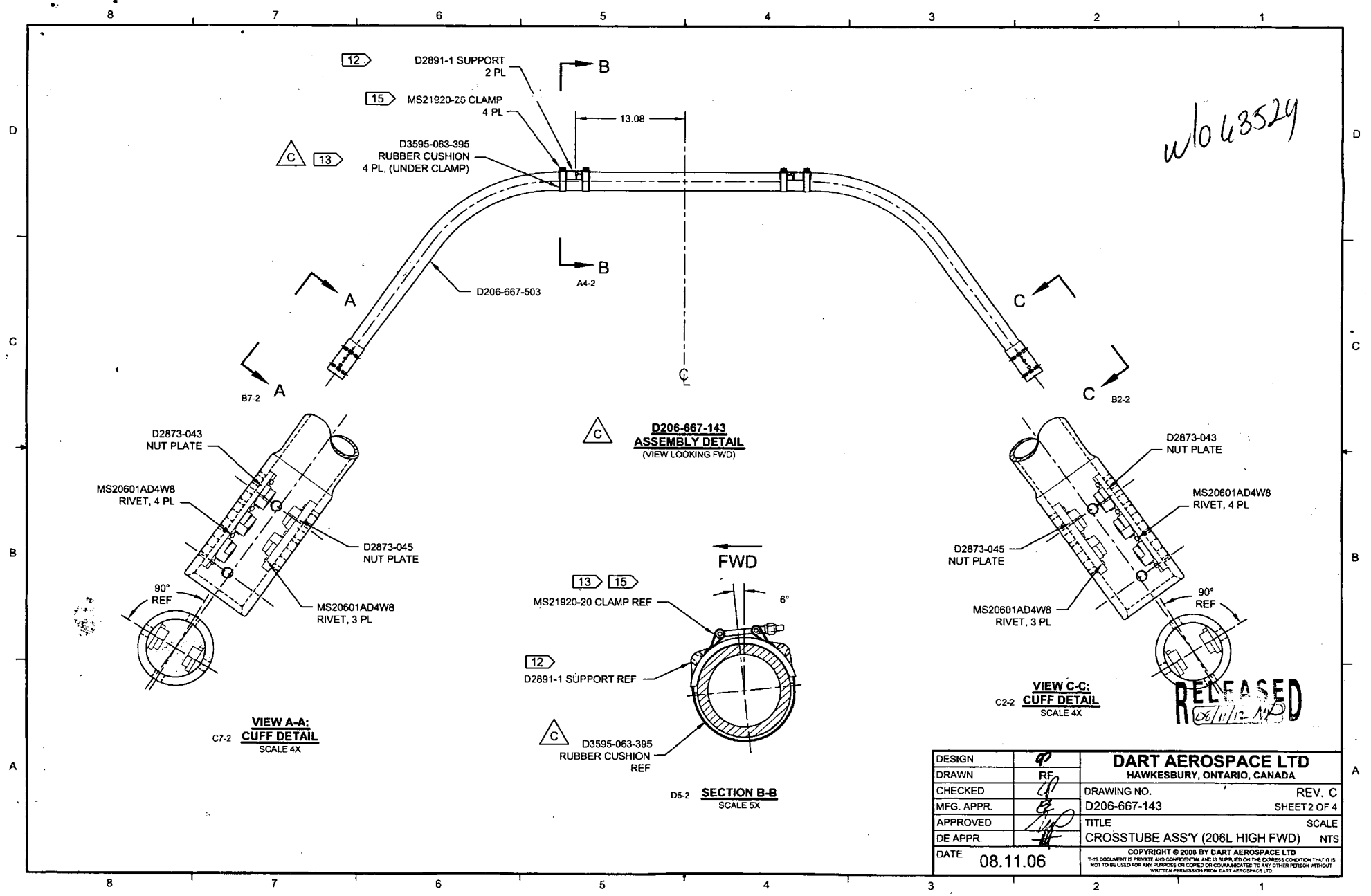
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

w/063524



VIEW A-A:
CUFF DETAIL
SCALE 4X

D206-667-143
ASSEMBLY DETAIL
(VIEW LOOKING FWD)

SECTION B-B
SCALE 5X

VIEW C-C:
CUFF DETAIL
SCALE 4X

RELEASED
2011/12/10

DESIGN	9	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	4	DRAWING NO.	REV. C
MFG. APPR.	4	D206-667-143	SHEET 2 OF 4
APPROVED	4	TITLE	SCALE
DE APPR.	4	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
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Dart Aerospace Ltd

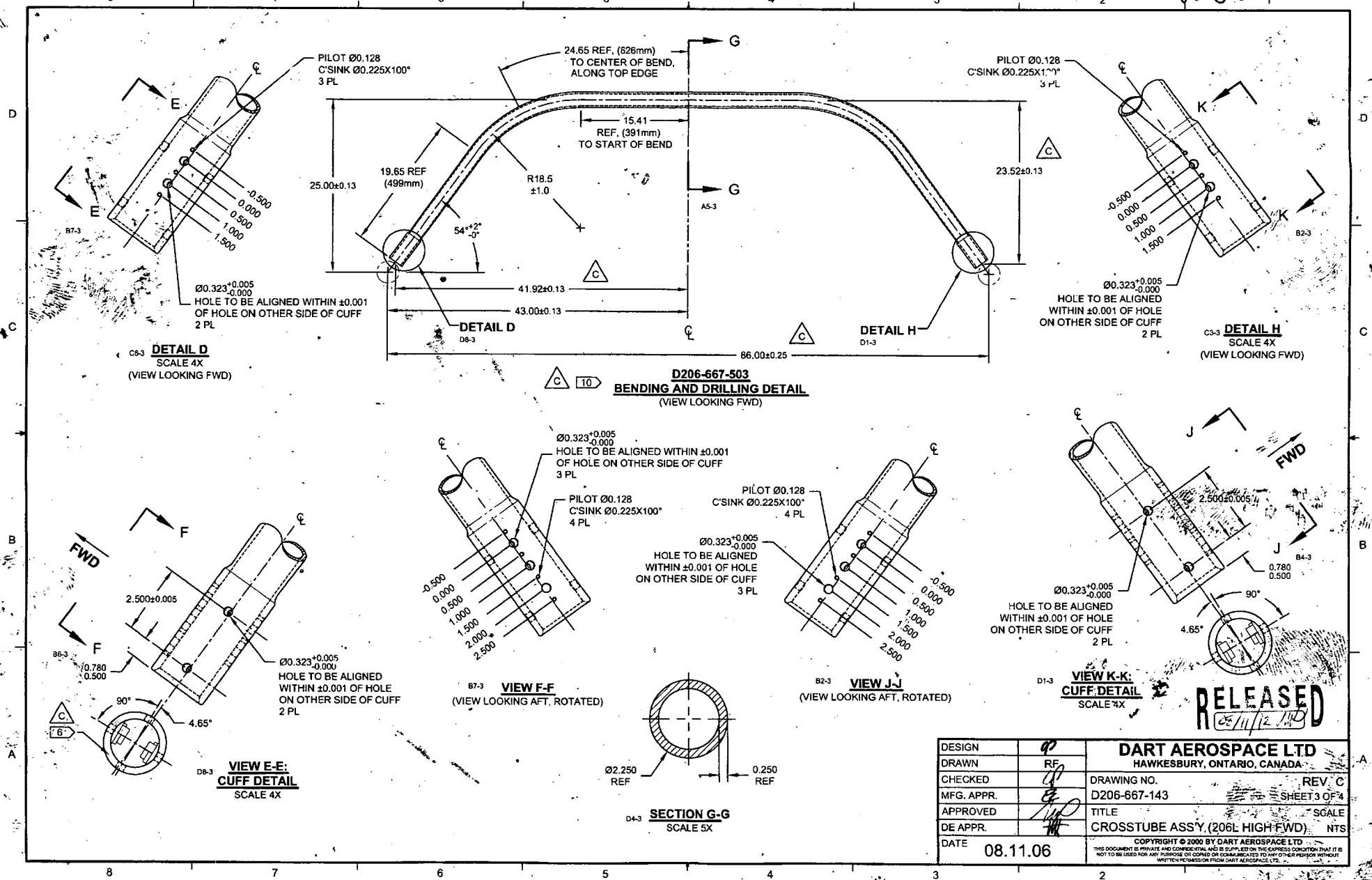
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W6 63524



DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-143	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASSY. (206L HIGH FWD)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

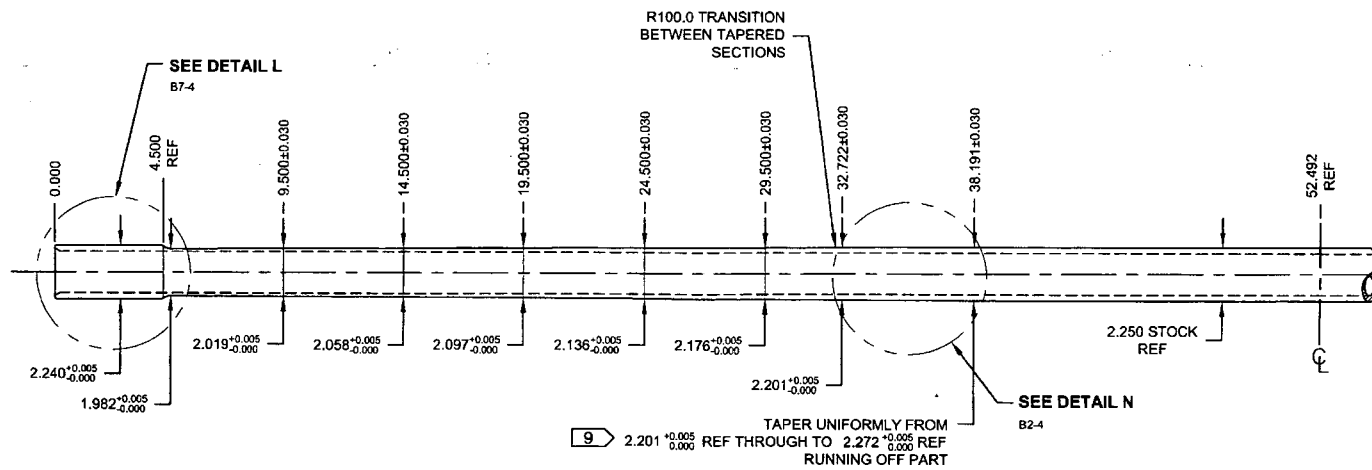
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

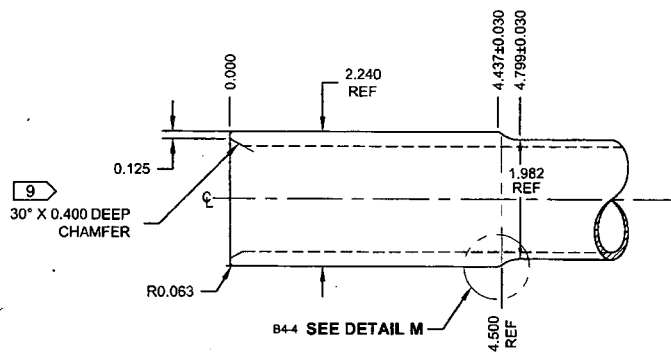
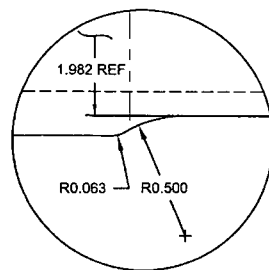
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W10 63524

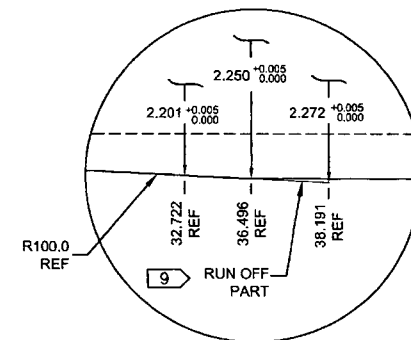


C TURNING DETAIL



DETAIL L:
D7-4 **CROSSTUBE CUFF**
NOT TO SCALE

DETAIL M:
A6-4 **CUFF TRANSITION**
NOT TO SCALE



DETAIL N:
C4-4 **TAPER RUN-OFF**
NOT TO SCALE

RELEASED

DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-143	SHEET 4 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: _____ PAR # _____ Fault Category: _____ NCR: Yes - No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



LIQUID PENETRANT TEST REPORT

P- 15201

CLIENT	DART Aerospace	DATE	FEB 10, 2011	PAGE	1	OF	1	
ATTENTION	LINDA LACELLE	ACUREN JOB No.	188-11-2008	TIME	AM	<input checked="" type="checkbox"/>	PM	<input type="checkbox"/>
ADDRESS	1270 ABERDEEN ST HAWKES BURY, CN.	POWO No.		WORK LOCATION	HAWKES BURY PLANT			
PROJECT	F.P.I.	ACCEPTANCE STD.	ASTM 1417	REV./DATE	2005			
ITEM(S) EXAMINED	6 CROSS TUBES 2 ENGINE MOUNTS							

JOB DESCRIPTION	PROCEDURE No. LT-2002 REV./DATE 2008	TECHNIQUE No. LT-2012 REV./DATE 2008
PART No.	MATERIAL Aluminum THICKNESS Varies	
SCOPE	WET FLUORESCENT LIQUID PENETRANT INSPECTION CARRIED OUT 100% EXTERNAL	

TEST DETAILS	
METHOD <input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH <input type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND MAGNA FLUX	BLACK LIGHT S/N 10459 <input type="checkbox"/> OUTPUT > 1000 μ W/cm ² <input type="checkbox"/> AMBIENT < 2 fc
PENETRANT 2LG7 MINIMUM DWELL TIME 45 MIN.	LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN.	OTHER LABINO
DEVELOPER S&D 52 MINIMUM DWELL TIME 10 MIN.	LIGHT METER S/N 1048866 CAL DUE DATE
DEVELOPER TYPE <input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY	007-19-2011

TEST SURFACE	
SURFACE CONDITION <input type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input type="checkbox"/> CLEAN BARE METAL	
SURFACE TEMPERATURE <input type="checkbox"/> < -4°C/ 20°F <input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F <input type="checkbox"/> 10°C/50°F TO 52°C/125°F <input type="checkbox"/> > 52°C/125°F	

RESULTS- <input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL
--

1 - CROSS TUBE - W.C. 63783	✓	accept reject BT 11-01-11
1 - CROSS TUBE - W.C. 63784	✓	
1 - CROSS TUBE - W.C. 63785	✓	
1 - CROSS TUBE - W.C. 63784	✓	
1 - CROSS TUBE - W.C. 64541	✓	
1 - CROSS TUBE - W.C. 64547	✓	
1 - ELEMENT ENGINE MOUNT	✓	
1 - W.C. 63456 - D3687-1	✓	
1 - ADD D3687-3	✓	

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

By performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES	
CLIENT REPRESENTATIVE	PRINT SIGNATURE
TECHNICIAN (SIGNATURE):	REPORT REVIEWED BY:
NAME (PRINT):	NAME INITIALS
CGSB LEVEL 2 SNT LEVEL	CGSB LEVEL SNT LEVEL
CGSB REG. No. 6606	CGSB REG. No.

REFERENCE ONLY

5.0 PARTS LIST

Item	Qty -011	Qty -013	Qty -015	Qty -101	Qty -201	Qty -103	Qty -203	Qty -105	Qty -205	Part Number	Description
	X									D206-667-011	SPACER BLOCK KIT
		X								D206-667-013	NUT PLATE KIT (-101/-103/-105/-203/-205)
			X							D206-667-015	NUT PLATE KIT (-201)
				X						D206-667-101	CROSSTUBE INSTALLATION, 206A/B HIGH FWD
					X					D206-667-201	CROSSTUBE INSTALLATION, 206A/B HIGH AFT
						X				D206-667-103	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH FWD
							X			D206-667-203	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH AFT
								X		D407-667-105	CROSSTUBE INSTALLATION, 407 HIGH FWD
									X	D407-667-205	CROSSTUBE INSTALLATION, 407 HIGH AFT
1				1						D206-667-141	CROSSTUBE ASSEMBLY, 206A/B HIGH FWD
2					1					D206-667-241	CROSSTUBE ASSEMBLY, 206A/B HIGH AFT
3						1				D206-667-143	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH FWD
4							1			D206-667-243	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH AFT
5								1		D407-667-145	CROSSTUBE ASSEMBLY, 407 HIGH FWD
6									1	D407-667-245	CROSSTUBE ASSEMBLY, 407 HIGH AFT
10				*2	*2	*2		*2		D2891-1	SUPPORT
11							*2			D2892-1	SUPPORT
12									*1	D2894-1	SUPPORT
13				*2	*2	*2		*2		D2856-400-694	ABRASION STRIP
14							*2		*2	D2856-400-773	ABRASION STRIP
15									*1	D2856-600-851	ABRASION STRIP
16				*4	*4	*4		*4		MS21920-20	CLAMP
17							*4		*4	MS21920-22	CLAMP
18									*2	MS21920-24	CLAMP
19				4	4	4		4		AN5-32A	BOLT
20							4		4	AN5-34A	BOLT
21				4	4	4	4	4	4	MS21042L5	NUT (OR MS21042-5)
22				8	8	8	8	8	8	AN960JD516	WASHER
23									*2	D3190-1	CHAFING SHIELD
30	8									AN4-6A	BOLT
31	8									AN4-7A	BOLT
32	16									AN960JD416	WASHER
33	2									D3193-041	SPACER BLOCK ASSEMBLY
40		2		*2		*2	*2	*2	*2	D2873-043	NUT PLATE
41		2		*2		*2	*2	*2	*2	D2873-045	NUT PLATE
42			2		2					D2872-043	NUT PLATE
43			2		2					D2872-045	NUT PLATE
44		10		10		10				AN5-7A	BOLT
45		10	10		10		10	10	10	AN5-10A	BOLT
46		4	4	4	10	4		4		AN5-30A	BOLT
47		4					4		4	AN5-32A	BOLT
48		18	18	10	12	10	10	10	10	AN960JD516	WASHER
49		4	4		6					MS21042L5	NUT (OR MS21042-5)

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-141/241/143/243, & D407-667-145/245 ASSEMBLIES ABOVE

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Revision: C

Date: 05.07.26

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. 2

REF CANADIAN STC: SH01-5
REF FAA STC: SR01304NY
REF EASA STC: EASA.IM.R.S.01179

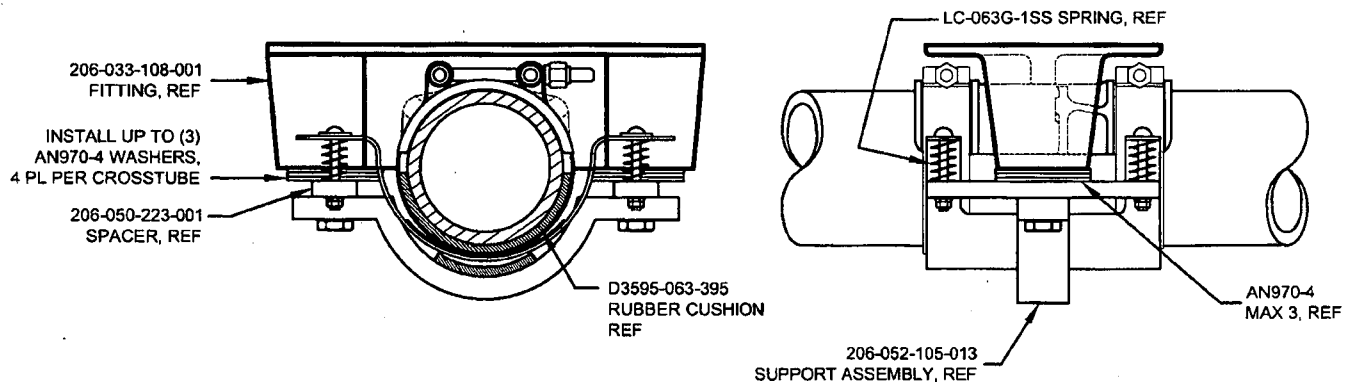
REFERENCE ONLY

PROBLEM:

FOR D206-667-103 CROSSTUBES (206L FWD) AT CHG 003 AND SUBSEQUENT (SEE DSI 9415) PROPER INSTALLATION OF THE OEM SUPPORT ASSEMBLIES MAY BE IMPOSSIBLE DUE TO THE ADDITIONAL THICKNESS OF THE DART D3595-063-395 RUBBER CUSHIONS. THE 206-052-105-013 SUPPORT ASSEMBLY (OR EQUIVALENT) MAY SIT TOO HIGH RELATIVE TO THE 206-033-108-001 FITTING, CAUSING THE LC-063G-1SS SPRING (OR EQUIVALENT) TO BE OVERLY COMPRESSED.

SOLUTION:

IT IS ACCEPTABLE TO LOWER THE SUPPORT ASSEMBLY BY INSTALLING UP TO QTY (3) AN970-4 WASHERS BETWEEN THE 206-033-108-001 FITTING (OR EQUIVALENT) AND THE 206-050-223-001 SPACER (OR EQUIVALENT). SEE FIGURE BELOW FOR REFERENCE.



CROSSTUBE SECTION: SUPPORT DETAIL

PARTS LIST:

THE FOLLOWING PARTS HAVE BEEN INCLUDED WITH D206-667-103 CROSSTUBES AT CHG 004 AND SUBSEQUENT

ITEM	Qty -103	PART NUMBER	DESCRIPTION
60	12	AN970-4	WASHER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 08.12.17
CERT. NO.: SH01-5
ISSUE NO.: 3

A	NEW ISSUE	CP	08.12.17
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>92</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>92</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9439	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206L FWD XTUBE SUPPORT MOD.	NTS
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